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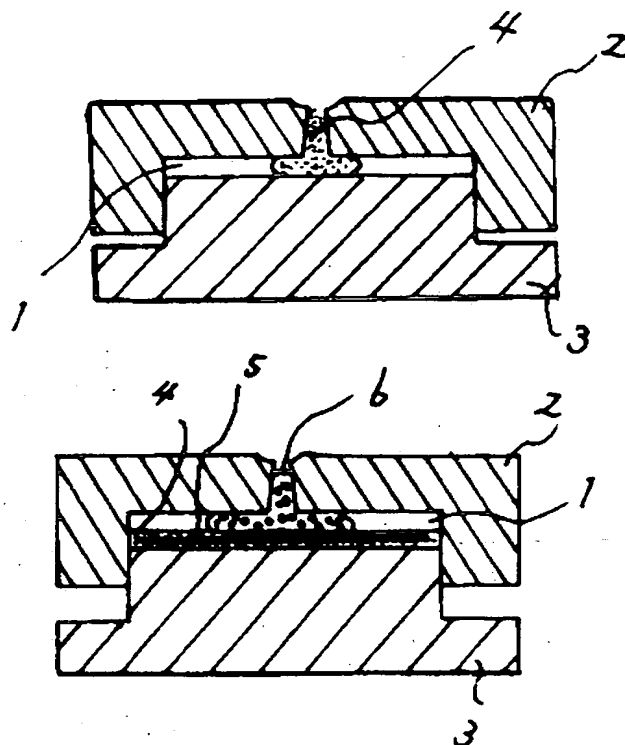
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TITLE : MULTILAYER INJECTION MOLDING



ABSTRACT : PURPOSE: To obtain a multilayered injection molding having a shape sharply taking over the shape of a mold cavity and a strongly adhered resin layers by a method in which a multilayered molding composed of the first resin and the second resin is injected and then the third resin is injected by increasing the volume of the cavity of molds.

CONSTITUTION: Molds used are the ones whose cavity 1 is changed its thickness by relatively sliding an injector side mold 2 and an opening and closing cylinder side mold 3. In the first place, the first resin 4 in an amount enough not to fill up the first molding cavity is injected into the first molding cavity whose volume is previously regulated to the volume of final molding, and while the center of the first resin 4 is in a fluid state, the second resin 5 is injected into the first resin 4. After molding a multilayered molding by such a multilayer injection molding method, the molding cavity 1 is opened to such a degree that the thickness of final molding can be obtained and then the third resin 6 sufficiently compatible with the first resin 4 is injected.

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